

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001889**Date Inspected:** 05-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Huang Wen-Pang and Chen Chih-CWE			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006 **Component:** OBG side and bottom panels

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present During the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG bay 3

QA observed ZPMC personnel fitting and tack welding T and bar stiffeners to the following side and/or bottom panels: SP-409-001, SP-359-001 and SP-410-001. Tack welders were continuously monitored by ZPMC Quality Control (QC) inspectors through out the day. Fitters appeared to be tacking under the guide lines of WPS# WPS-B-P-2112-FCM.

QA observed ZPMC qualified welding personnel performing fillet weld repairs on stiffener to panel fillet welds on bottom panel BP-165-001. Welder appeared to be following repair procedure WPS-345-FCAW-2G (2F) repair 1. ZPMC QC Certified Welding Inspector (CWI) identified as Mr. Huang Wen-Pang was observed monitoring the repairs.

QA observed ZPMC personnel flame straightening side panel SP-472-001 which appeared to have been distorted during the welding process. ZPMC personnel appeared to be performing the process in accordance with an approved flame straightening procedure HSR-1-(B)-368.

Gantry 2

QA observed ZPMC qualified welding personnel preheat and commence welding of fillet welds on SP-424-001

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

stiffeners. Welding started at 1400hrs. QA departed this area before welding was complete.

QA observed a variety of other operations in this area including parts beveling in preparation for welding, stiffener bars being cut and wide flanges being split into T beams.

OBG new assembly bay

QA observed ZPMC qualified welding personnel performing FCAW root weld on side panel SEG-019A-015 joining panel SP-061 to SP-049. QC CWI inspector identified as Chen Chih-Ming was observed monitoring the weld parameters for compliance to the posted WPS. They appeared to comply and are as follows:

Volts: 28 Amps: 290

QA observed ZPMC qualified welding personnel perform the SAW intermediate and cap welds on side panel SEG-013A-002. ZPMC QC inspectors were observed monitoring the weld parameters for compliance to the posted WPS. They appeared to comply and are as follows:

Volts: 32 Amps: 633 Travel Speed: 487mm/m

QA observed a variety of other operations in this area including construction of the OBG fixture, trimming, cleaning and grinding OBG side and bottom panels.



Summary of Conversations:

No significant conversations were held today concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowery (858)-344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hall, Steven	Quality Assurance Inspector
----------------------	--------------	-----------------------------

Reviewed By:	Cuellar, Robert	QA Reviewer
---------------------	-----------------	-------------
